

Work Order ID 63679

November 10, 2010 8:49:25 AM

FRIDAY

~~SALE~~



Item ID: D429-793-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw Installation

Stop



Start Date: 11/10/10 Start Qty: 5.00

Required Date: 11/15/10 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *U*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D429-793

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D429-793-011 CHG

11/10/10

8:01/10/10

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/11/10 *(S)*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8:01/10/10

(X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63679

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Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D429-793-011
Location:

FG14 MVA

140

0.00



QC

Memo

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/11/25 (5)

10/11/26
MF
10-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 10, 2010 8:49:23 AM

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Work Order ID: 63679

Parent Item: D429-793-011

Parent Item Name: Bearpaw Installation

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 5.00

Required Qty: 5.00

Comments: Rev. A New Issue 10/10/18 DL
Change AN4C12A bots to AN4C13A bolts 10/11/05 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4C13A

Purchased

No

110

Each

58.0000

8

40

BOLT

Location

Loc Qty

Loc Code

ST357

58

113359

3

114442

5

114615

50

AN4C15A

Purchased

No

110

Each

199.0000

4

20

Bolt

Location

Loc Qty

Loc Code

ST358

199

115835

99

115936

100

D2274

Manufactured

No

110

Each

397.0000

12

60

Radius Block

Location

Loc Qty

Loc Code

ST010

397

59108

4

61361

78

62658

315

D3980-041

Manufactured

No

110

Each

0.0000

2

10

Bearpaw Assembly

114615

115835

59108/24

62658 484

63681

11/10/25
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 10, 2010 8:49:23 AM

Page 2 *B*

Work Order ID: 63679

Parent Item: D429-793-011

Parent Item Name: Bearpaw Installation



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 5.00

Required Qty: 5.00

<i>S/S</i> D4176-1 429 Clamp, Top	Manufactured	No	110	Each	0.0000	6	30	63683 27
<i>S/S</i> D4176-3 429 Clamp, Bottom	Manufactured	No	110	Each	0.0000	2	10	62421 28 62703 1X <i>B</i>
<i>S/S</i> D4211-041 Wearplate	Manufactured	No	110	Each	0.0000	2	10	B62707 58 B63688 48 <i>B</i>
<i>S/S</i> D4212-1 429 Clamp Cushion	Manufactured	No	110	Each	0.0000	6	30	63686 <i>B</i>
<i>S/S</i> MS21043-4 Nut	Purchased	No	110	Each	822.0000	12	60	63687 <i>B</i>

Location

Loc Qty

Loc Code

FG	40
104603	40
ST301	782
112492	25
113069	8
114523	149
114784	300
115936	300

1114784

11/11/25 (5)

November 10, 2010 8:49:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3 / 3

Work Order ID: 63679

Parent Item: D429-793-011

Parent Item Name: Bearpaw Installation



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

110

Each

1,857.000

24

120

✓



Washer



11/11/20 (5)

Location

Loc Qty

Loc Code

ST298

1857

10096

10

114576

68

115622

45

116025

1734

11/16/20

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Shop Packet Print

Page 3

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NOTE: Date & initial all entries

3.0 INSTALLATION PROCEDURE

- 3.1 Jack up the aircraft.
- 3.2 Skid wearplates and/or wear pads may be removed in the area of the Ultrapaw™. Seal holes using Sikaflex- 241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant. Ensure skid is serviceable and free from wear and/or damage.
- 3.3 If installing the Ultrapaw™ over the wearplates/wear pads, the Ultrapaw™ may be relieved to clear wearplates/wear pads mounting screws provided the relief leaves 0.125" (3.18 mm) minimum thickness.
- 3.4 Install a D3980-041 Ultrapaw™ Assy on the aft end of each skidtube using the D4176-1/-3 Clamps, D4212-1 Clamp Cushion, D4211-041 Wearplate and associated hardware as shown in Figure 2.
CAUTION: The torque on the nuts should be limited to 20 in-lb to allow the Ultrapaw™ to rotate as the landing gear spreads.
Note: To ease installation, it is recommended to loosely install the two aftmost set of clamps onto the Ultrapaw™ and then slide the Ultrapaw™ over the aft end of the skidtube before installing the fwd clamp.
- 3.5 Although not generally necessary, it is acceptable to use longer or shorter AN4 bolts to ensure 1.5-4 threads in safety on the nuts. Additional NAS1149D0463J washers may also be installed under the nuts.
- 3.6 Lower the aircraft

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D429-793-011	21.0 lb	0.0 in	0.0 lb-in	275.8 in	5792 in-lb
Ultrapaw™ Installation	9.5 kg	0.0 m	0.0 m-kG	7.0 m	66.5 m-kG

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D429-793-011	ULTRAPAW™ INSTALLATION
12	D2274	RADIUS BLOCK
2	D3980-041	ULTRAPAW™ ASSY
6	D4176-1	CLAMP, TOP
2	D4176-3	CLAMP, BOTTOM
2	D4211-041	WEARPLATE
6	D4212-1	CLAMP CUSHION
8	AN4C13A	BOLT
4	AN4C15A	BOLT
12	MS21043-4	NUT
24	NAS1149D0463J	WASHERS

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Revision: B
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Tooling:

Date:

Run Start



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Date:

SPC (Y/N):

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Stop



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Draw Nbr	Revision Nbr
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IIN-D429-793	B
--------------	---

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D429-793-011 CHG

11/10/10

Solub

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

120



QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

Solub

11/11/10

15

11/02/02

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/02/09	1202	Boxes were opened, new stickers were applied then contents were verified and boxes repacked.	Wm	11/02/09	4/11	11-0209	

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D429-793-011
Location:

FG14 MVA

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11-01-04

FG 14

10/11/25 (5)

10/11/26

MF
10-11-25

Ph
11/02/09